

Date: Tuesday, 11/14/2006 10:03:46 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOOR PROTCOR FWD LH
Job Number :	29424		
Estimate Number :	11227		
P.O. Number :	N/A	Part Number :	D32811
This Issue :	11/14/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3281 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	27508	Drawing Revision :	B
		Material :	N/A
		Due Date :	12/20/2006
Written By :			
Checked & Approved By :			
Comment :	Est Rev:A 04.07.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 2495

Description: Floor Protector Fwd, LH

Possible Supplier: Delastek

Certificate of Conformity is required

C20611115 (10)

2.0	D32811P	Floor Protector, Fwd LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Floor Protector Fwd, LH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

07/1/22 (10)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

07/01/23 (10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPR B294 08 12/0

07/01/23 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: P Date: 07/01/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:03:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR FWD LH

Job Number: 29424

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/01/24 (10)

Job Completion



U 07.06.24

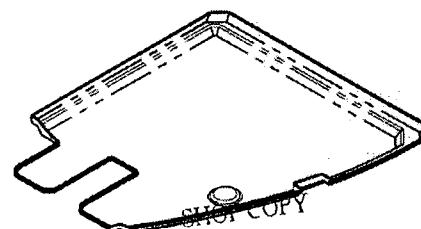
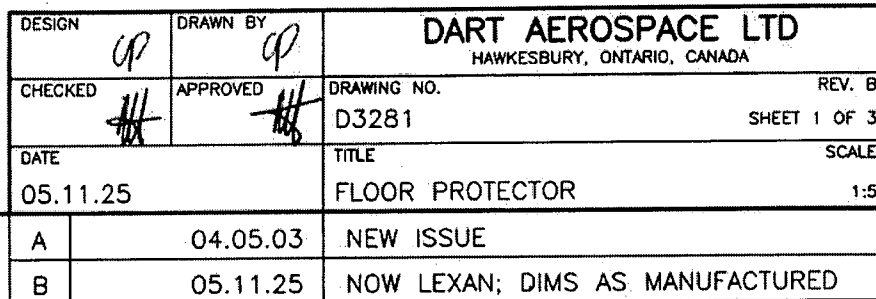
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
05.12.01

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

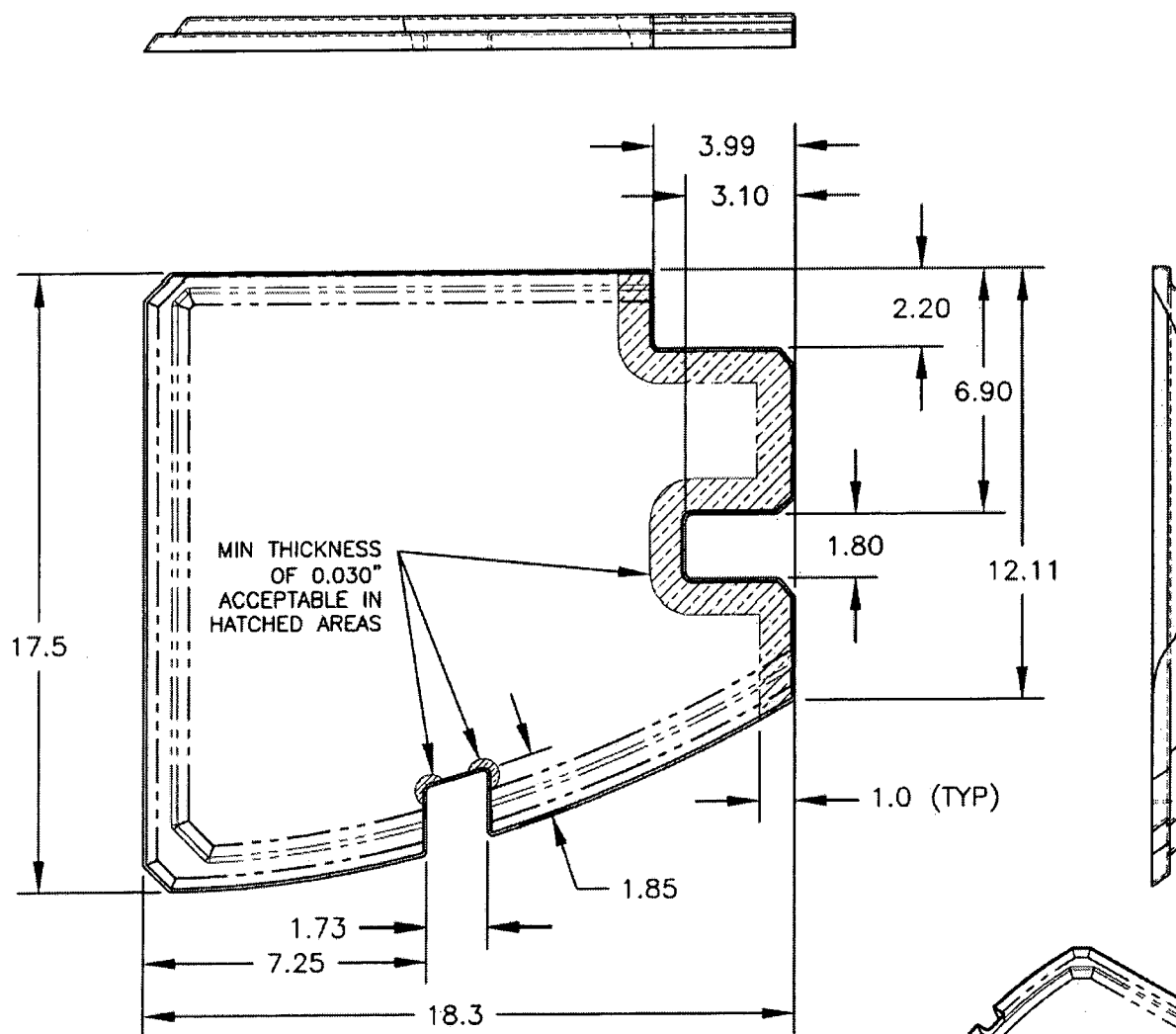
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29424

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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
05.12.01 *[Signature]***D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

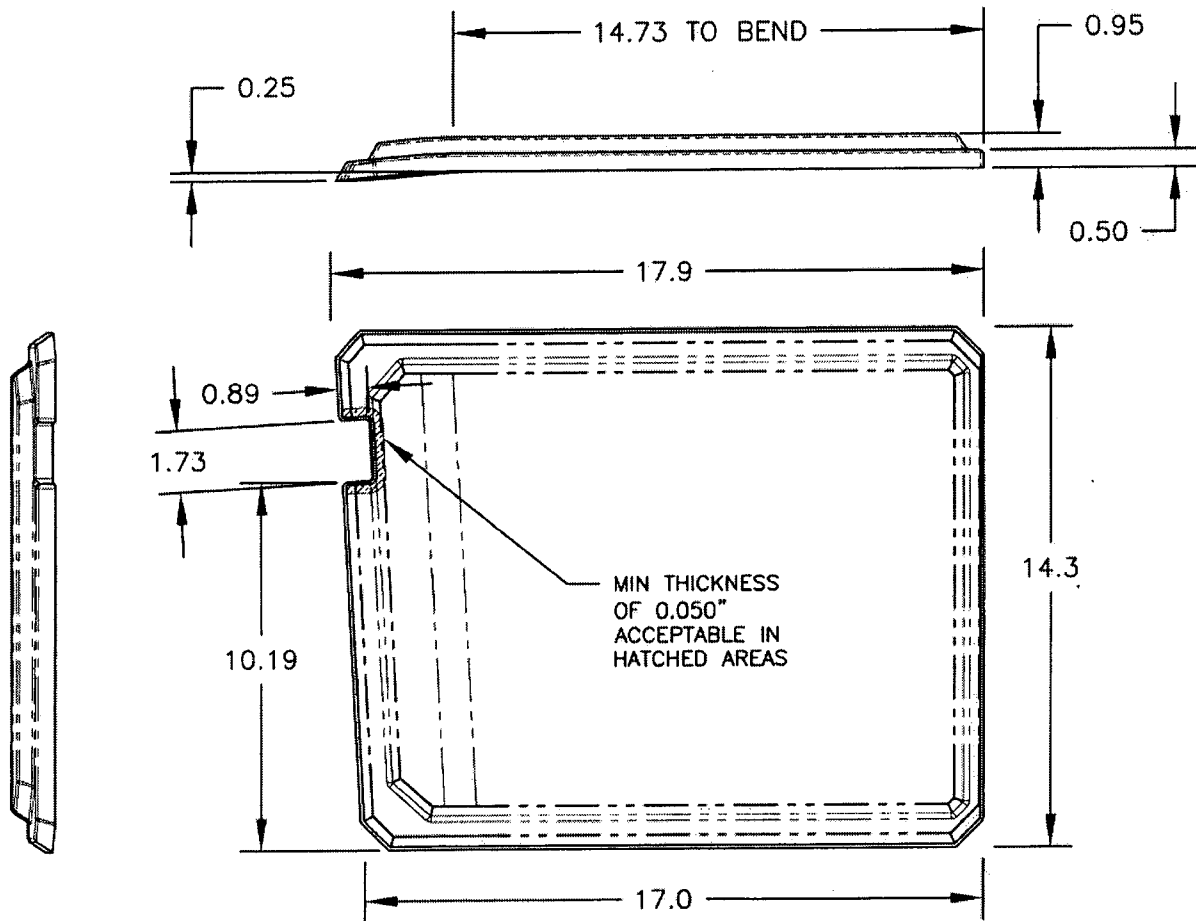
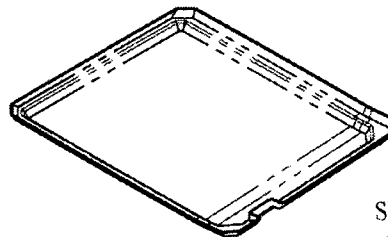
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HL</i>	APPROVED <i>HL</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**RELEASED**
05.12.01. *HL*

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2NCONTROLLED COPY
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2SUBJECT TO AMENDMENT
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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ENGINEERING
WITHOUT NOTICE
WORK ORDER
NO. **29424**

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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11497
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336


Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson		
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233		
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #		
19/01/07	15/11/06	5017	C. Lavoie	PO00002495				
Order Qty	B.O. Qty	Current Ship	Item #	Item Description				
10	0	10	DKC134-0044	Floor Protect Part 1 N° D3281-1 (F6006) B29424 Selon dessin D3281 Rev.: B Job: 40353				U de M : Each
10	0	10	DKC134-0046	Floor Protect Part 3 N° D3281-3 (F6006) B29426 Selon dessin D3281 Rev.: B Job: 40356				U de M : Each
10	0	10	DKC134-0047	Floor Protect Part 4 N° D3281-4 (F6006) B29427 Selon dessin D3281 Rev.: B Job: 40357				U de M : Each

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

 19/01/07
Quality department AQ-357

Jeudi, 2006-11-16 15:00:51

Sylvie Hamel

Feuille de Procédé

ent : DART Dart Aerospace Ltd.
 méro Job : 40353
 méro Soumission : 2383
 méro B.A. :
 tte fois : 2006-11-16 No. B.V. :
 sht Rev. : NC
 am. fois : - - Type :
 b précédente : 36892

Nom Dessin : FLOOR PROTECTOR
 Numéro Article : DKC134-0044
 Numéro Dessin : D3281
 Projet Numéro : DKC134
 Révision dessin : B
 Matériel : F6006
 Date Dûe : 2006-12-08

Qté: 25 Udm: UNITE

rit par :
 rifié & Approuvé par :
 mmentaires : N° de pièce: D3281-1

Process Sheet Rév.: 00 Création du premier

oduit additionnel

iméro Job:



Séq.: Machine ou Opération: Description :

1.0 APL0016 Lex'

APL0016

Commentair Qty.: 0.167 UNITE(s)/Unit Total: 0.835
 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
 # Bon achat: 5913

3-5913-1

N° de Lot:

2.0 SÉCHAGE/ANEAL SÉCHAGE / ANEALING



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.1667Hrs
 SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.
 Inscire sur la charte de température le numéro de Job du matériel au séchage.
 # de cuisson: 3463


3.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 15.0000Hrs
 TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 25 Date: 10-1-07 Sceau: 

Quantité: Date: Sceau:

e: Jeudi, 2006-11-16 15:00:52

igateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 40353

Numéro Article: DKC134-0044

Numéro Job:



Séq.: Machine ou Opération: Description :

4.0

THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 0.8333Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-1 à l'aide du moule N° D3281-1T1 sur le thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 25 Date: 10-1-07 Sceau: _____



10 ceps

Quantité: _____ Date: _____ Sceau: _____

5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.8333Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-1 à l'aide du gabarit de trimage N° D3281-1T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 25 Date: 12-01-07 Sceau: _____



Quantité: _____ Date: _____ Sceau: _____

6.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.4167Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 25 Date: 18-01-07 Sceau: _____

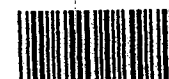


Quantité: _____ Date: _____ Sceau: _____

7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.4167Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Isateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR

Numéro Job: 40353

Numéro Article: DKC134-0044

Numéro Job:



Séq.: Machine ou Opération: Description :

N° de pièce: D3281-1

N° de Job: 40353

Date de fabrication: 15-1-07

Sceau d'inspection.

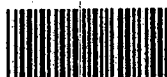
Quantité: 25 Date: 15-1-07 Sceau: ER

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.4167Hrs

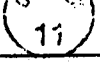
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-1

Date de fabrication: _____

N° de job: _____

Quantité: 25 Date: 18/1/07 Sceau: 

Quantité: _____ Date: _____ Sceau: _____